

Work Order ID 52345

Tuesday, September 22, 2009 1:56:37 PM



Page 1

Item ID: D3846-7

Accept



Setup Start



Revision ID: B

Stop



Item Name: GASKET

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

PL MK

Date:

09-22

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3846

B

NOT PULLED

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3846

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

IB 9-10-10

(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 9-10-10

Work Order ID 52345

Tuesday, September 22, 2009 1:56:37 PM



Page 2

Item ID: D3846-7

Accept



Setup Start



Revision ID: B

Stop



Item Name: GASKET

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00

2809/10/13



QC

Memo

0.00

(X6)

/

Quality Control

130

Identify as per dwg & Stock Location: F.A. 15/11/13 0.00

Packaging

Memo

0.00

Packaging

C 9/10/13 (K)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/19 AJ

W 9.10.16

Picklist Print

Tuesday, September 22, 2009 1:56:36 PM

Page 1

Work Order ID: 52345



Parent Item: D3846-7RevB



Parent Item Name: GASKET

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	99.6648	5.3221	8.000		
NEOPRENE SHEET 0.063												139-10-10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

99.66475853

111853

-4.147E-05

112508

99.6648

112866

112866

DART AEROSPACE LTD		Work Order: 52345
Description: Gasket		Part Number: D3846-7
Inspection Dwg: D3846	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300 x 0.300	+/-0.010	301 x 303	X			
Ø0.219	+0.005/-0.001	.220	X			
2.39	+/-0.030	2.345	X			
3.20	+/-0.030	3.196	X			
4.02	+/-0.030	4.014	X			
1.69	+/-0.030	1.695	X			
12.74	+/-0.030	12.74	X			
25.48	+/-0.030	25.48	X			
28.98	+/-0.030	28.98	X			
38.15	+/-0.030	38.15	X			
41.65	+/-0.030	41.65	X			
10.00	+/-0.030	10.00	X			
20.00	+/-0.030	20.00	X			
30.00	+/-0.030	30.00	X			
45.28	+/-0.030	45.28	X			
0.063	+/-0.010	.057	X			

Measured by: IB	Audited by: S	Prototype Approval: N/A
Date: 9-10-10	Date: 09/10/13	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	AI

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52345

D3846-1 GASKET

D3846-3 GASKET

D3846-7 GASKET

D3846-5 GASKET

D3846-9 GASKET

D3846-11 GASKET

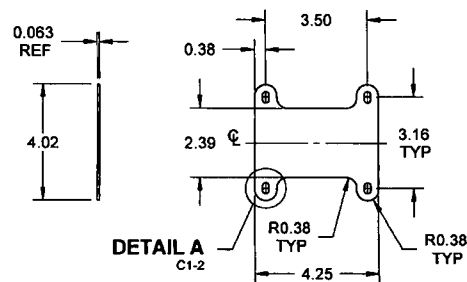
RELEASED
09/07/15

NOTES:

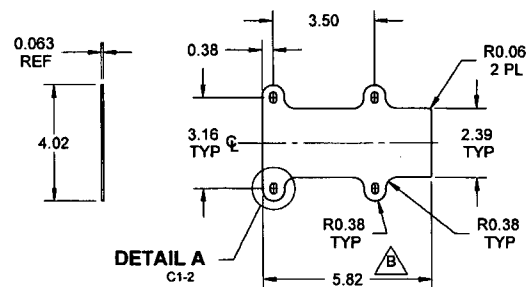
- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
(REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3846-X" USING YELLOW PAINT MARKER
- 7) WEIGHT:
D3846-1 = 0.03 lbs
D3846-3 = 0.25 lbs
D3846-5 = 0.20 lbs
D3846-7 = 0.26 lbs
D3846-9 = 0.35 lbs
D3846-11 = 0.04 lbs

B	5.82 WAS 6.25 (ZN C4-2); 45.28 WAS 45.71 (ZN A4-3); 6.32 WAS 6.75 (ZN B2-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3846	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	GASKET	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

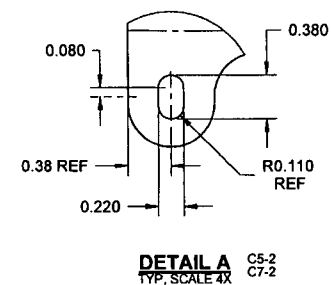
52345



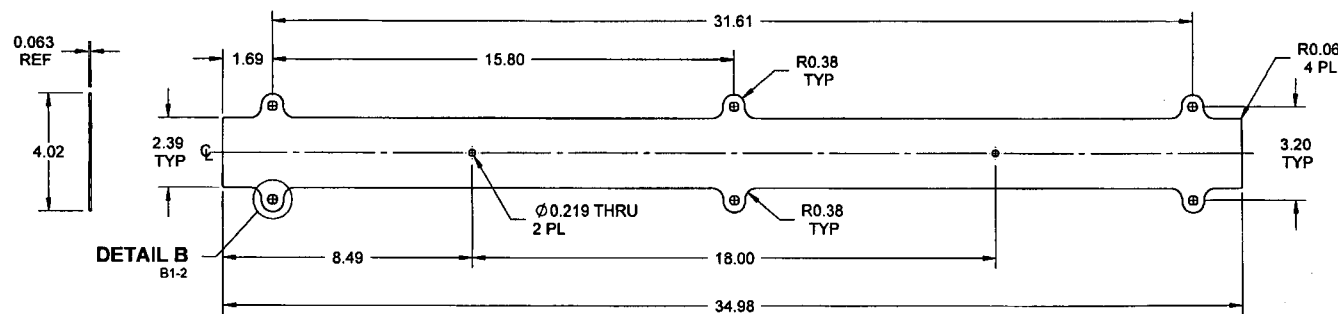
D3846-1 GASKET



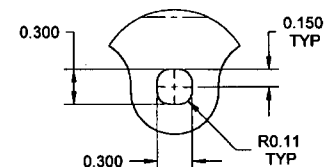
D3846-11 GASKET



DETAIL A C5-2
TYP, SCALE 4X C7-2



D3846-5 GASKET

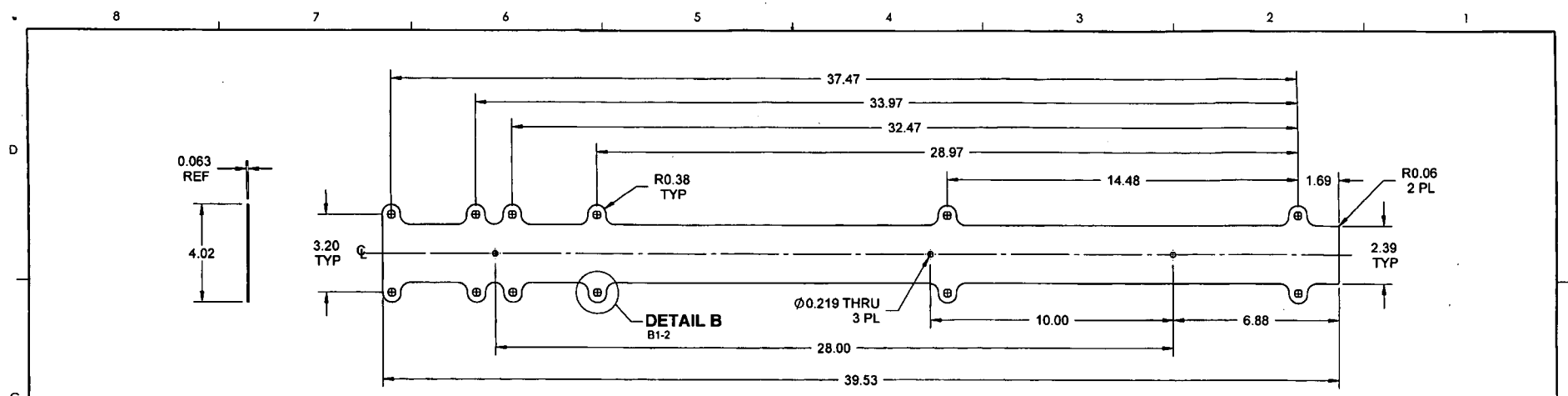


DETAIL B A7-2
TYP, SCALE 4X B7-3
C5-4

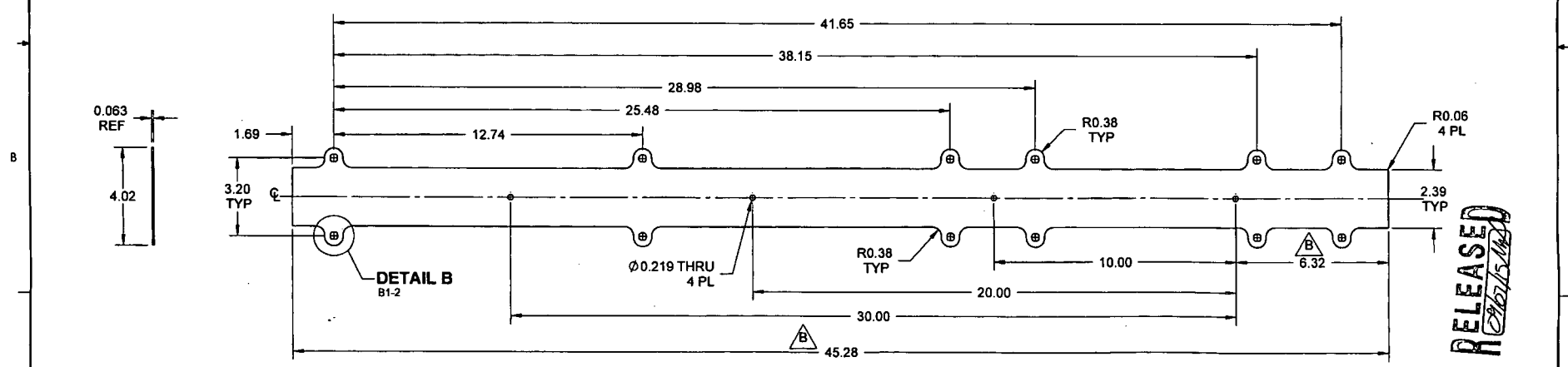
RELEASED
CARTON

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3846	SHEET 2 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	GASKET	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

52345



D3846-3 GASKET



D3846-7 GASKET

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>RF</i>	DRAWING NO. D3846	REV. B
MFG. APPR.	<i>RF</i>	SHEET 3 OF 4	
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	GASKET	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

RELEASED
09/15/2010

8	7	6	5	4	3	2
---	---	---	---	---	---	---



B

A

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D3846	SHEET 4 OF 4
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	GASKET	NTS
DATE 09.06.30		COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS RETURNED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIES OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	